

Patent Abstracts of Japan

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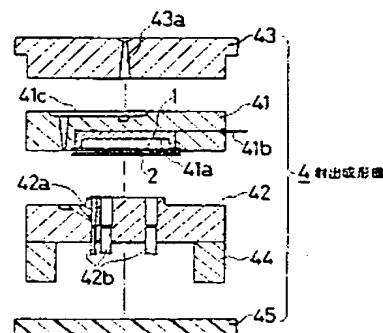
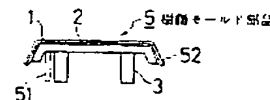
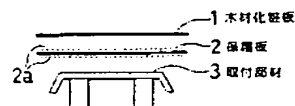
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TITLE : METHOD FOR MOLDING RESIN
MOLDED ITEM HAVING WOODEN
OVERLAY SHEET AS SURFACING
MATERIAL



ABSTRACT : PURPOSE: To obtain apparently realistic woody texture and contrive to enhance the productivity and to reduce the production cost of the molded item concerned through the reduction of the number of processes by a method wherein both the shaping of a curved real wood and the injection molding of a mounting member are performed simultaneously and both the wood and the member are bondingly integrated at the molding.

CONSTITUTION: Firstly, a wooden overlay sheet 1 and a protective plate 2, which comes into contact with the back of the sheet 1 and on both sides of which adhesive is applied, are set to a cavity 41a. The holding of the sheet and the plate for setting is performed by provisionally fixing to the cavity part through the suction under vacuum 41b. Injection molding is performed by injecting thermoplastic synthetic resin to the nozzle touching part of a retainer plate 43 after mold closing. The resin is injected through the sprue 43a of the retainer plate 43 to the runner 41c of a cavity main body 41 and further through the gate pole 42a of a movable retainer plate 42 to the rear side of the protective plate 2. At this time, the wooden overlay sheet 1 and the protective plate 2 are fixed by pressure to the cavity of the cavity main body 41 so as to be integrally bonded together and, at the same time, to be shaped in the predetermined surface form by the cavity. Simultaneously, a mounting member 3 is injection molded on the rear side of the protective plate 2.

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